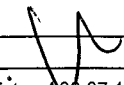
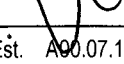


Date: Friday, 27/04/2007 12:43:20 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LABEL PLATE
Job Number : 32023	
Estimate Number : 11639	
P.O. Number : <i>N/A</i>	Part Number : D2983
This Issue : 27/04/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2983 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 23/04/2007 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : 	Due Date : 07/05/2007 Qty: 10 Um: Each
Checked & Approved By : 	
Comment : Est. A90.07.12 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

SHEAR

SHEAR



Comment: SHEAR

Make as per Dwg D2983

Deburr

N/A

2.0

M5052H32S032

5052-H32 .032 Sheet



Comment: Qty.: 1.9332 sf(s)/Unit Total: 19.3316 sf(s)

5052-H32 .032 Sheet

Material: 5052-H32 or 6061-T6 0.032" thick

Batch *M103321*

SAD 07/06/14

(10)

3.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2983

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

SAD 07/06/14

SAD 07/06/14

(10)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

OKD 07/06/14

(10)

PTO

Date: Friday, 27/04/2007 12:43:20 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 32023

Part Number: D2983

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 02/06/18 (15)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/06/26

(10X)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/26 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/27 (10X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/27 (10)

Job Completion



U 07-06-27

Date: 4 Monday, 4/23/2007 3:41:56 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LABEL PLATE
Job Number	: 32023		
Estimate Number	: 11639		
P.O. Number	:	Part Number	: D2983
This Issue	: 4/23/2007 S.O. No. :	Drawing Number	: D2983 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 5/7/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>407.04.23</u>		
Comment	: Est. A 00.07.12 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S032	5052-H32 .032 Sheet
-----	--------------	---------------------



Comment: Qty.: 1.9332 sf(s)/Unit Total : 19.3316 sf(s)
 5052-H32 .032 Sheet
 Material: 5052-H32 or 6061-T6 0.032" thick
 Batch _____

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Make as per Dwg D2983
 Deburr

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

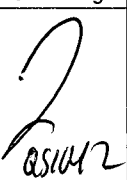
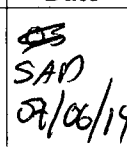
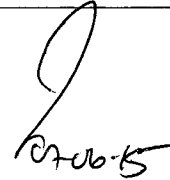

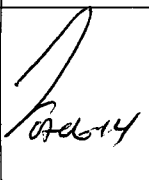
5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/06/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/14	2.0	One part was Scrap because the jet offset had to be change to 0.019 instead of 0.015		Scrap destroy, replace	 SAD 07/06/14			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:41:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 32023

Part Number: D2983

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(18)

Comment: FINAL INSPECTION/W/O RELEASE

5/09/06/07

Job Completion



u 8/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

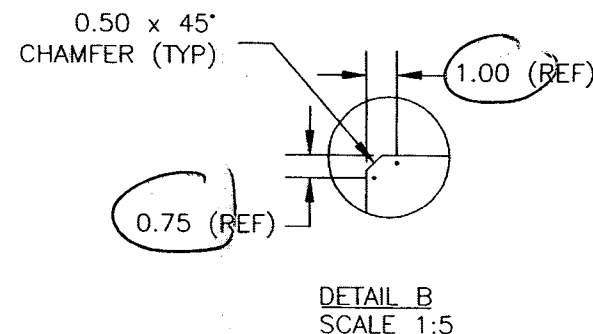
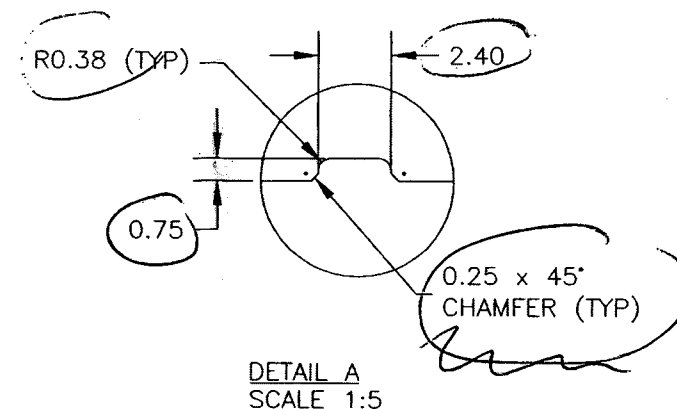
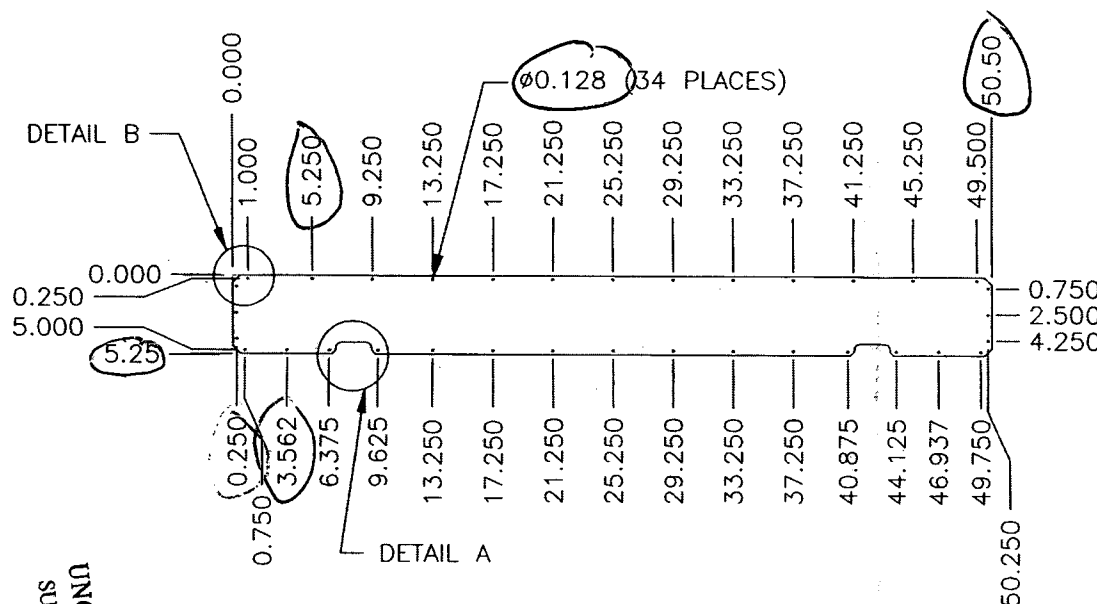
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
00.07.06



NO 32023
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

MATERIAL: 5052-H32/H34 (QQ-A-250/8) OR 6061-T6
(QQ-A-250/11) 0.032 THICK
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		00.07.06		NEW ISSUE	
DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD. WARRICKLAW, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. A
DATE	00.07.06	TITLE	D2983		SHEET 1 OF 1
			LABEL PLATE		SCALE 1:8

DART AEROSPACE LTD		Work Order: 32023
Description: LABEL Plate		Part Number: D2983
Inspection Dwg: D2983 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.25	± 0.030	5.260	✓		Vern	
B 50.50	± 0.030	50.50	✓		M-T	
C $\varnothing 0.128$	± 0.005 -0.001	$\varnothing 0.128$	✓		Vern	
D 0.750	± 0.030	0.760	✓		Height gage	
E 5.250	± 0.010	5.258	✓		Vern Height gage	
F 3.562	± 0.010	3.560	✓		Vern	
G 0.75	± 0.030	0.74	✓		Height gage	
H 1.00	± 0.030	0.99	✓		Vern Height gage	
I 0.032	± 0.010	0.031	✓		Vern	
J 2.40	± 0.030	2.39	✓		Vern	
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: En	Prototype Approval:	N/A
Date: 07/06/15	Date: 07/06/15	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved